

Work Order ID 103102

June-13-13 12:54:53 PM

Shop 19/06

103102

Page 1

Item ID: D2199-25

Accept

N900040100

Setup Start

NS1

Revision ID:

RW01

Stop

NS2

Item Name: Strut

Start Date: 6/13/13

Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/17/13

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

V

Date: _____ Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2199	Rev E1								
100		0.00							<i>FF</i>
100 Brake NC	NC BRAKE Memo	<i>cutoat 20.18</i>	0.00					<i>4</i>	<i>Ø</i>
Brake NC		Punch per Dwg D2199 and Spec Control Dwg D2638							<i>13-06-13</i>
110		0.00							
110 Small Fab	Small Fab Memo	0.00						<i>4</i>	<i>Ø</i>
Small Fab		Deburr							<i>13-06-13</i>
120	QC5- Inspect part completeness to step on W/O QC	0.00	<i>DAS 21</i>	0.00				<i>4</i>	
Quality Control	Memo								
			<i>13 6 14</i>						

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Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut

Start Date: 6/13/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/17/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Powdercoat

Powder Coating

Memo

START TIME:

12-10 00

OVEN TEMPERATURE:

400 0 F

FINISH TIME:

12-40

140

QC3- Inspect Part Finish

0.00

0211

140

QC

Quality Control

Memo

0.00

13634

150

Identify as per dwg & Stock Location: 512-604 0.00

150

Packaging

Packaging

Memo

0.00

4X 0 M-F 13/06/14

4

4X 80 13-6-14

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Item ID: D2199-25

Accept

N900040100

Setup

Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut

Start Date: 6/13/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/17/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

160

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

13/6/17 JF

MF
13/6/17

Picklist Print

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Page 1

Work Order ID: 103102

Parent Item: D2199-25

Parent Item Name: Strut

Start Date: 6/13/13

Required Date: 6/17/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.03.05 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 304 RD Tube .750 x .049W		Purchased	No			100	f	480.1769	1.66	6.9894737		FF 13-06-13	

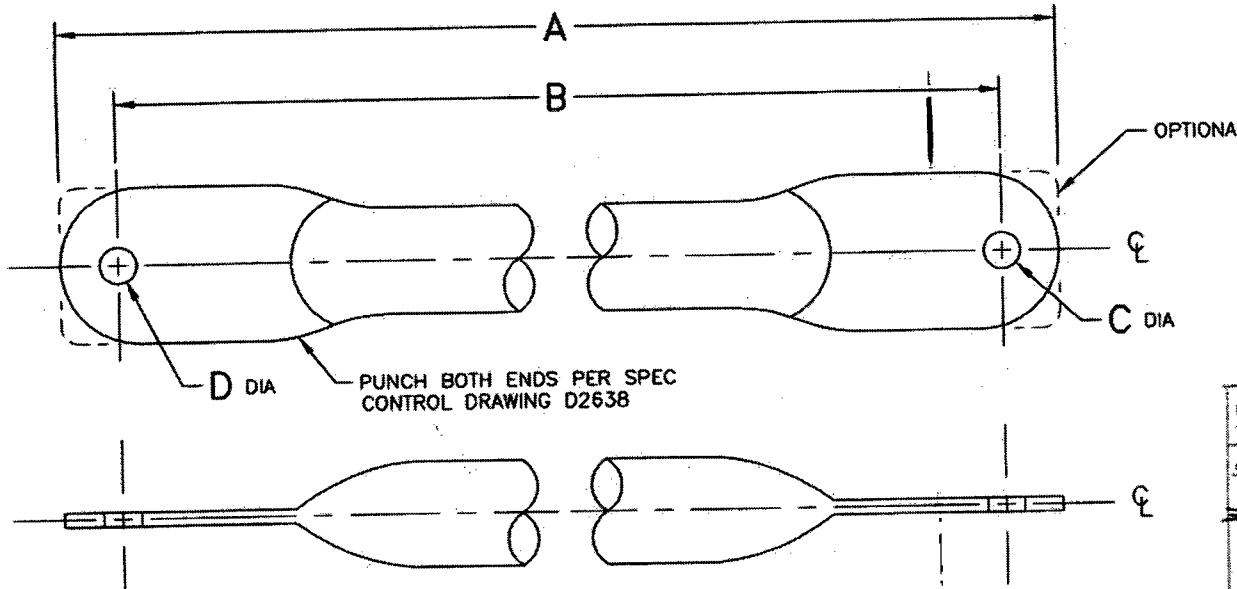
Location	Loc Qty	Loc Code
MAT017	480.1768825	
122312	13.3	
122468	0.0000325	
124768	83.93245	
<u>125068</u>	93.9444	
125513	289	

6.9894



RELEASE
1980-05-05
EE

DRAFT AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA	
DESIGN	DRAWN BY <i>[Signature]</i>	APPROVED	REV. E
CHECKED	DATE	DRAWING NO.	SHEET 1 OF 1
<i>[Signature]</i>	98.04.28	D2199	SCALE
A	TITLE	STRUT DETAILS	NTS
B	1993	NEW ISSUE	
C	ADDED - 11, - 13, AND - 15		
D	ADDED - 17 AND - 19		
E	ADDED - 21		
E1	98.04.28	ADDED - 23 AND - 25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	ADD FINISH



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

NOTES:

NOTES:
1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\varnothing 0.750 \times 0.049$ WALL
3. FINISH: POWDER COAT WHITE (43.5.2) PER DART QSI 005 43/EA